

# EUROPEAN PATENT OFFICE

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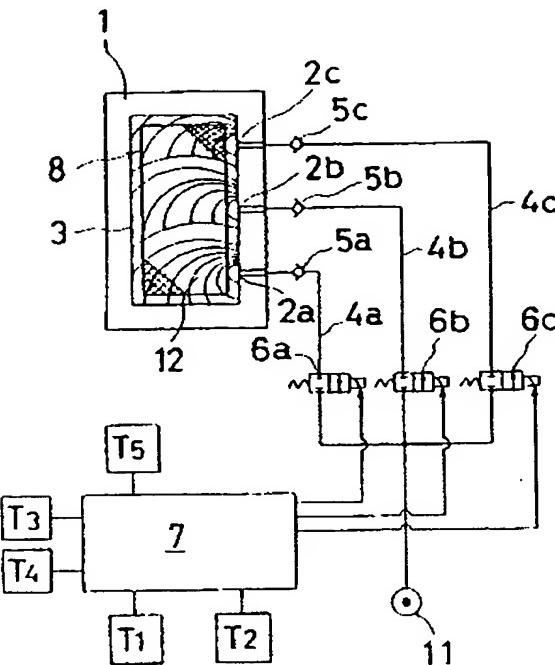
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APPLICANT : NISSEI PLASTICS IND CO;

INVENTOR : TAKEHIRO TOSHIAKI;

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TITLE : MOLDING METHOD FOR FIBER REINFORCED RESIN MOLDED PRODUCT



**ABSTRACT :** PURPOSE: To infiltrate resin among fibers and mold a fiber reinforced resin molded product of superior strength by inserting fibercloth, mats and the like in a cavity of a mold and injecting resin from a plurality of gates provided in the cavity step by step and injecting at the respective gates intermittently.

CONSTITUTION: Insert materials 8 such as fiber, both mats and the like are inserted into a mold 1, and then clamped. A signal for starting injection is issued from a controller 7 to an operation section of a selector valve 6a, and the selector valve 6a is opened by the action of a solenoid to pressure inject liquid resin 12 from a first gate 2a into a cavity 3. The injection of said resin 12 is limited by the set time, and then switched over to a second gate 2b and further to a third gate 2c. The injection is carried out intermittently at the respective gates. The cavity 3 can be pressure reduced, or supersonic vibration can be applied to the resin in the cavity. Thus, a molded product without unevenness of resin infiltration can be molded.

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